

Work Order ID 91428

91428

Page 1

Item ID: D4541-6

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 10/10/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12-10-10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4541

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg(CUT D4541-5)

Prog rev: E

Dwg rev: E

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10

B12-11-5

10

B12-11-5

Work Order ID 91428

91428

Page 2

October-10-12 9:08:03 AM

Item ID: D4541-6

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 10/10/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

125

0.00

125

Small Fab

Memo

0.00

Small Fab

BEND TABS PER DWG

127

QC5- Inspect part completeness to step on W/O

0.00

127

QC

Memo

0.00

Quality Control

Abdine

QC

12/11/19

15 12/11/19

15

Work Order ID 91428

October-10-12 9:08:03 AM

91428

Page 3

Item ID: D4541-6

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 10/10/2012 Start Qty: 15.00 ***15***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00 ***15***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>St 163</u>	0.00							
150									
Packaging	Memo	0.00				15			12/11/21 JB
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*
 MF
 12-11-21

Picklist Print

October-10-12 9:08:08 AM

Page 1

Work Order ID: 91428

91428

Parent Item: D4541-6

D4541-6

Parent Item Name: Bracket

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.05.08 as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	700.0600	0.3606	5.693684			

M6061T6S 0.32

6061-T6 Sheet 0.032"

B/L-11-5

Location

Loc Qty

Loc Code

MAT021

700.06

121099

85.97

122256

40.89

122737

30.1

123097

91.1

123135

96

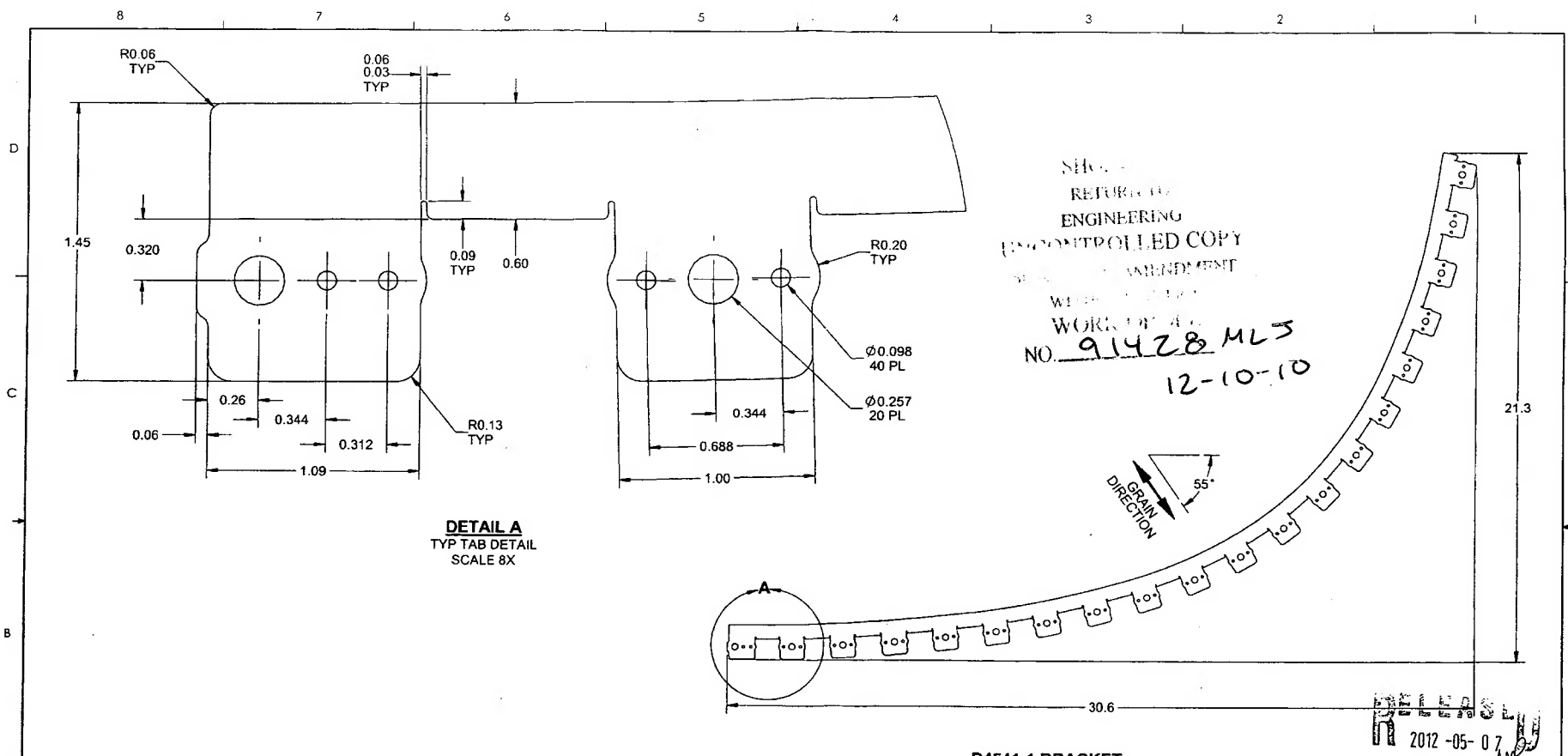
123137

356

(15)

~~123458~~

123483



SHOWN
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WORK OF A
NO. 91428 ML3
12-10-10

DETAIL A
TYP TAB DETAIL
SCALE 8X

D4541-1 BRACKET

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-1-REVC.DXF"

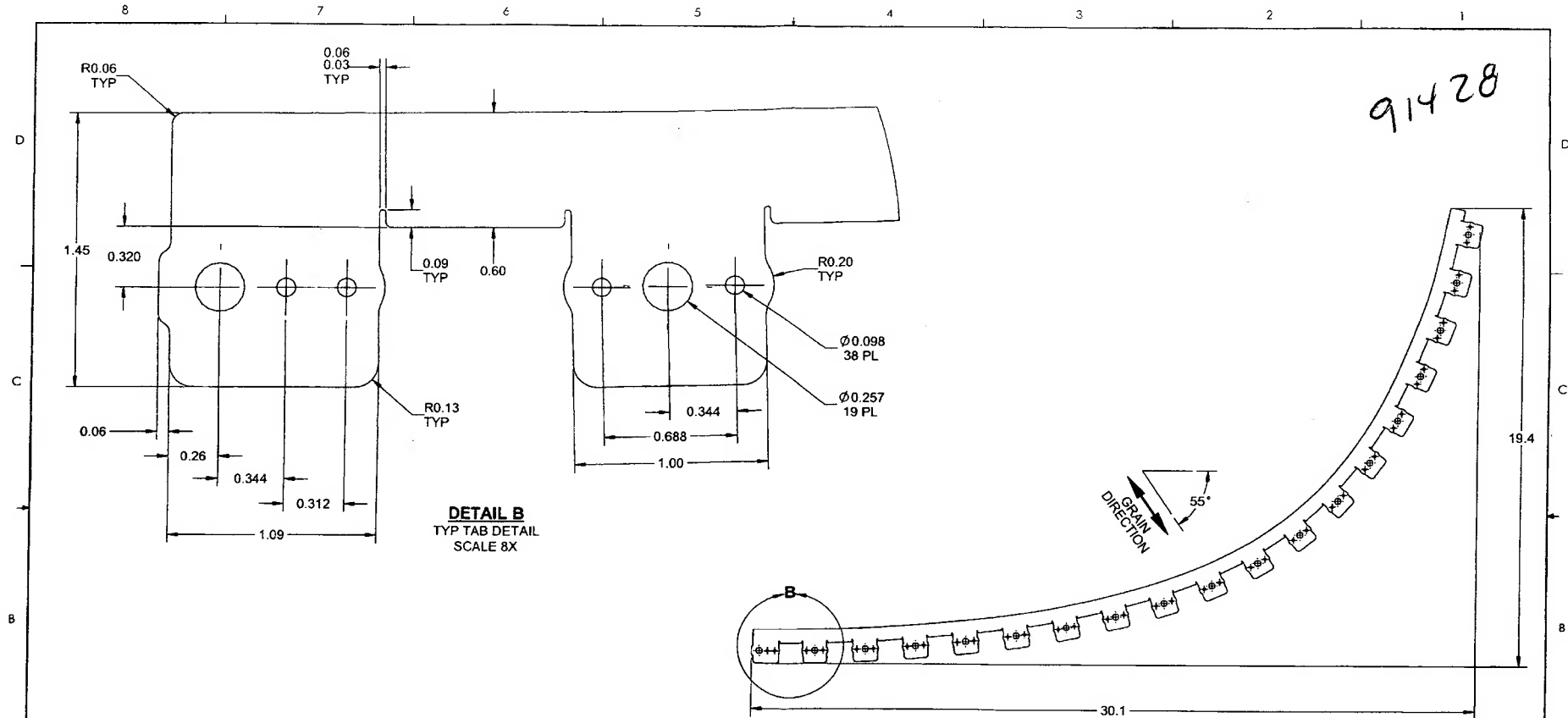
C	D4541-5F WAS -5; ADD -5/6; RMV FINISH (-1/2/-3/-5/-7); 0.70 WAS 0.60 (ZN D1-3)	CP	12.04.20
B	-5: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	ASS		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	12.04.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4541
REV. C
SHEET 1 OF 7
SCALE
NTS

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D4541-2 BRACKET

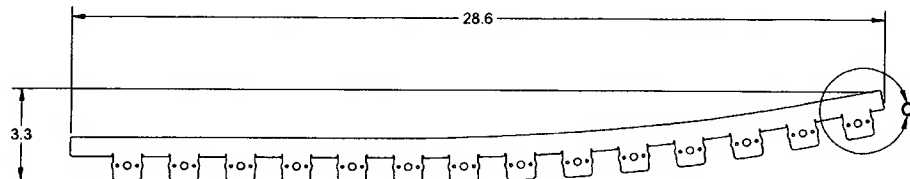
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2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-2-REVC.DXF"

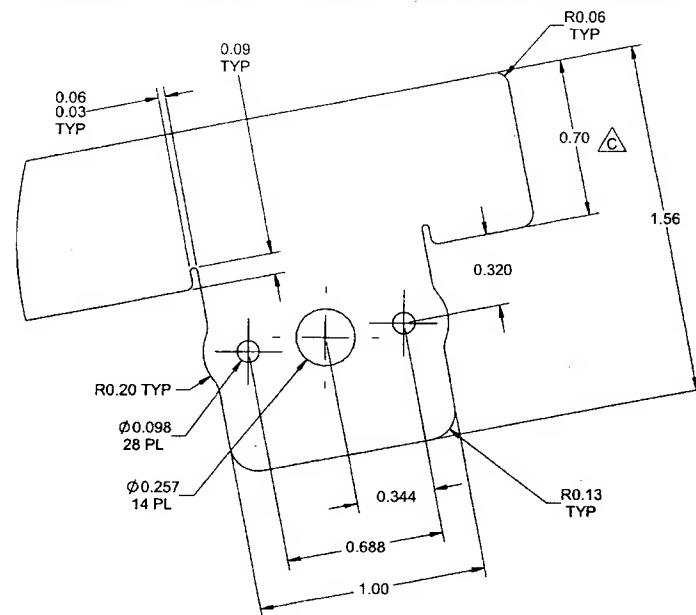
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D4541-3 BRACKET

GRAIN
DIRECTION



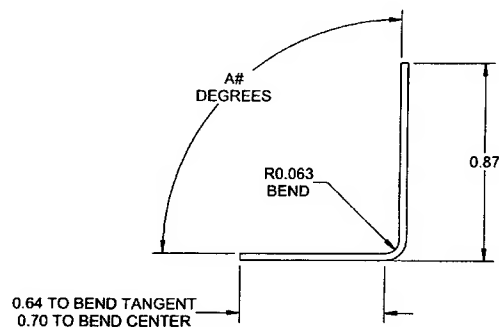
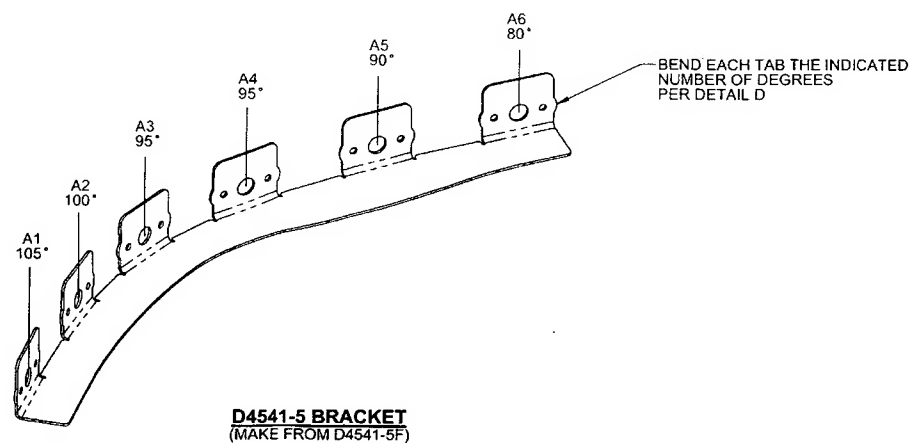
DETAIL C
TYP TAB DETAIL
SCALE 4X

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2012-05-07
JMD

- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.09 lbs
 - 8) PROFILE PER DRAWING FILE "D4541-3-REVC.DXF"

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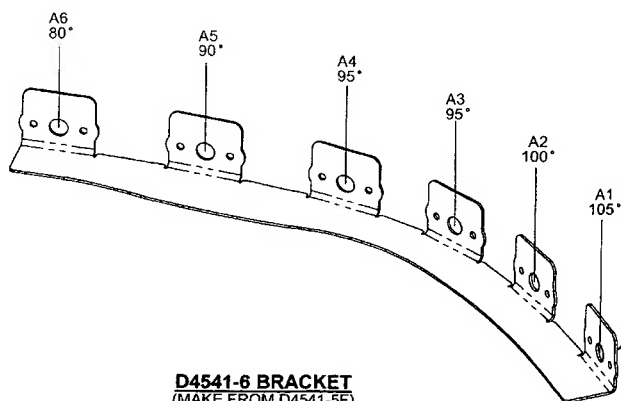
NOTES:

- 1) MATERIAL: MAKE FROM D4541-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

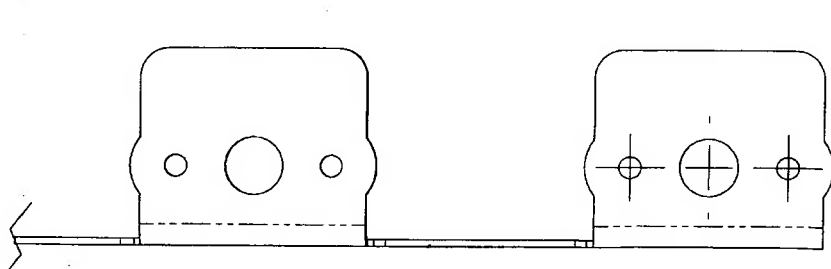
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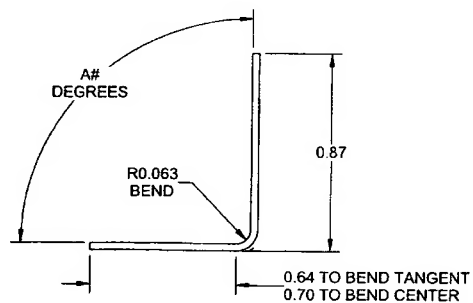
91428



D4541-6 BRACKET
(MAKE FROM D4541-5F)



DETAIL E
BEND DETAIL
SCALE 2X



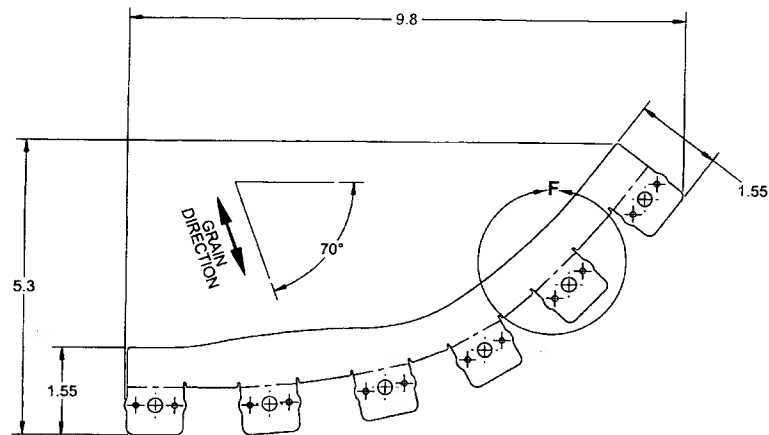
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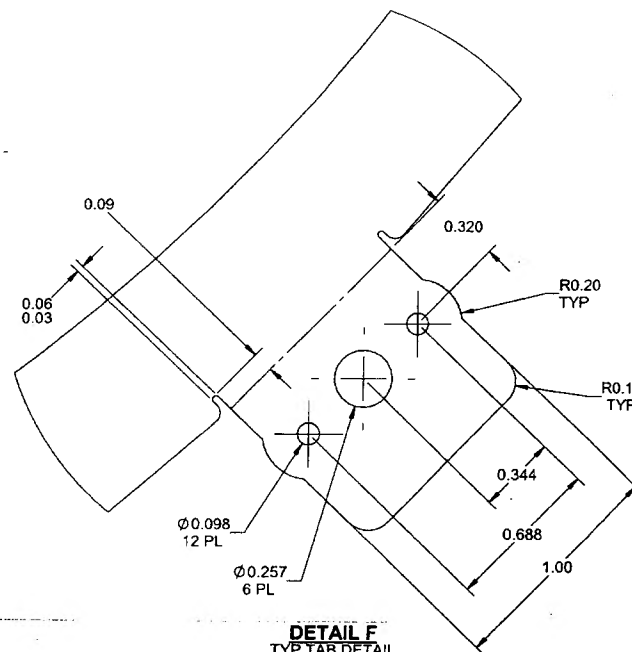
- 1) MATERIAL: MAKE FROM D4541-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4541	SHEET 5 OF 7
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D4541-5F FLAT PATTERN



DETAIL F
TYP TAB DETAIL
SCALE 4X

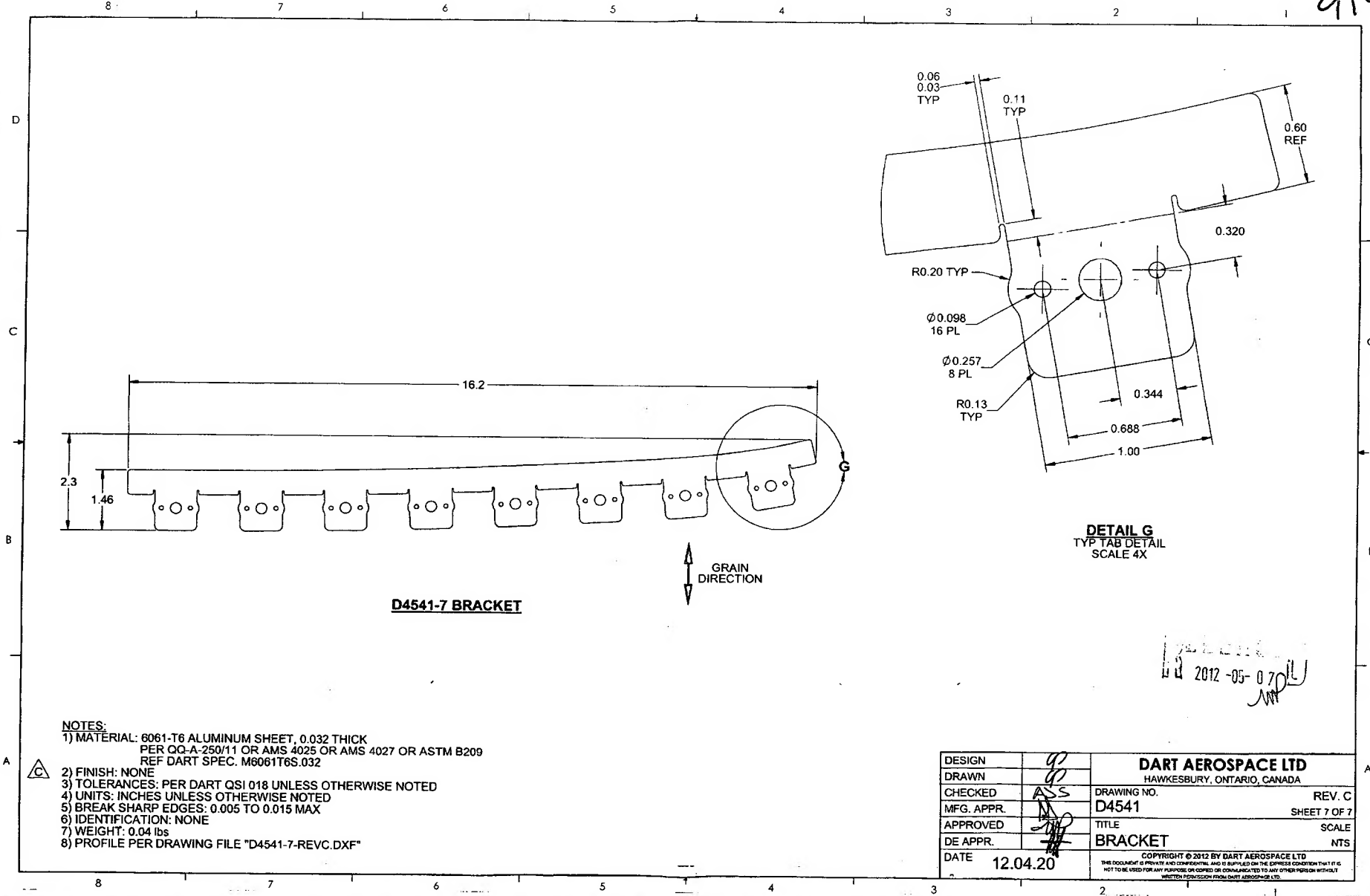
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2012-05-07
AN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4541-5-REVC.DXF"

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DETAIL G
TYP TAB DETAIL
SCALE 4X

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- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.04 lbs
 - 8) PROFILE PER DRAWING FILE "D4541-7-REVC.DXF"

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